

SHIP DEC 6TH

Work Order ID 153573

153573

Page 1

Tuesday, November 22, 2016 9:20:25 AM

Item ID: D4482-042 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Intercostal 5 Assembly, RH
Start Date: 11/28/2016 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 12/6/2016 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: VS / DAS 21 9-89 Date: 16/11/22 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4482	C								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AS PER DWG								
	SEE Attached								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.01							
Quality Control									

DEC 06 2016

Work Order ID 153573

Tuesday, November 22, 2016 9:20:25 AM

153573

Page 2

Item ID: D4482-042 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 12/6/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>5+102</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

DEC 05 2016 2 16/12/6 DAF
9-89 16-12-06

Picklist Print

Tuesday, November 22, 2016 9:20:31 AM

Page 1

Work Order ID: 153573

153573

Parent Item: D4482-042

D4482-042

Parent Item Name: Intercostal 5 Assembly, RH

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4482-2 *D4482-2* Intercostal 5, RH		Manufactured	No				Each	1.0000		2			
** 1XB B153574 ① NOV 22 2016 6													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST103		1					
						96297		1					
D4482-4 *D4482-4* Hinge Plate, RH		Manufactured	No				Each	2.0000		2			
** NOV 22 2016 6													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST103		2					
						96301		2					
D4488-1 *D4488-1* Clip		Manufactured	No				Each	10.0000		2			
** NOV 22 2016 6													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						ST104		10					
						96098		4					
						99086		6					

Picklist Print

Tuesday, November 22, 2016 9:20:31 AM

Page 2

Work Order ID: 153573

153573

Parent Item: D4482-042

D4482-042

Parent Item Name: Intercostal 5 Assembly, RH

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-3

Purchased

No

Each

5,649.000

4

MS20426AD3-3

RIVET

16/12/05 DAS 36 9-89

Location

Loc Qty

Loc Code

fg108

480

M134946

200

M135354

120

M135894

160

GA

2328

M135274

2328

ST312

2841

M135274

2841

MS20426AD4-4

Purchased

No

Each

3,605.000

4

MS20426AD4-4

Rivet

16/12/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

1648

125445

1648

ST312

1957

m132536

1957

MS20426AD3-5

Purchased

No

Each

3,766.000

6

MS20426AD3-5

Rivet

16/12/05 DAS 36 9-89

Location

Loc Qty

Loc Code

GA

2380

4533

2380

ST312

1386

4533

1386

Picklist Print

Tuesday, November 22, 2016 9:20:31 AM

Work Order ID: 153573

153573

Parent Item: D4482-042

D4482-042

Parent Item Name: Intercostal 5 Assembly, RH

Start Date: 11/28/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

MS21059L08

Purchased

No

Each

109.0000

2

MS21059L 08

NOV 22 2016

DAS
6
9-89

Nut

Location

Loc Qty

Loc Code

ST300

109

m134634

9

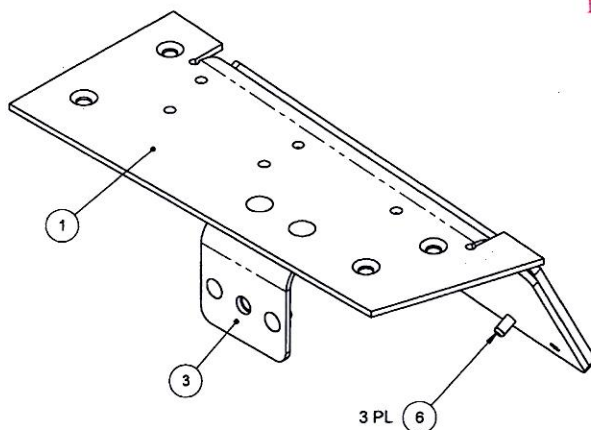
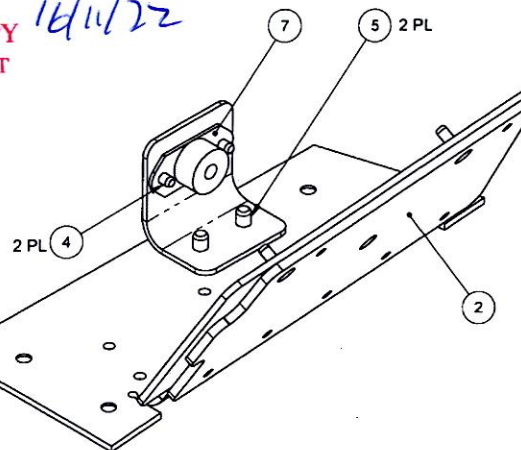
m134943

100

2

ITEM	QTY	P/N	DESCRIPTION
	X	D4482-041	INTERCOSTAL 5 ASSY (LH)
1	1	D4482-1	INTERCOSTAL 5 (LH)
2	1	D4482-3	HINGE PLATE (LH)
3	1	D4488-1	CLIP
4	2	MS20426AD3-3	RIVET, CSK
5	2	MS20426AD4-4	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153573



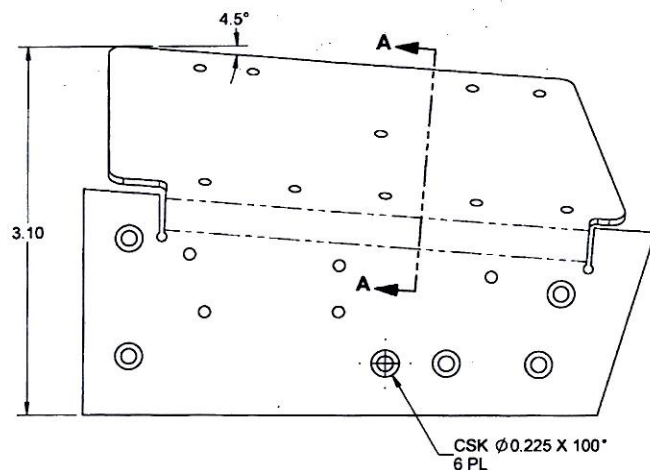
D4482-041 INTERCOSTAL 5 ASSY (LH)

NOTES:

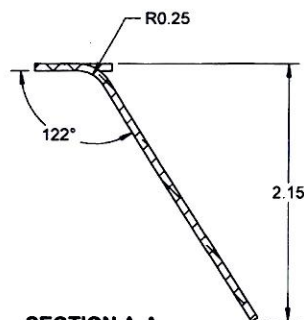
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

RELEASED
2012-11-29
WP

REV.	DESCRIPTION	BY	DATE
C	ADDED -042 & -2 (RH CONFIGURATION).	AJS	12.10.05
B	GENERAL REVISION SEE REV. A FOR DETAILS. ADDED -3. ADDED PRIMER NOTE.	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.02
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	BS	D4482	SHEET 1 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	INTERCOSTAL 5 ASSY	NTS
DATE	12.10.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



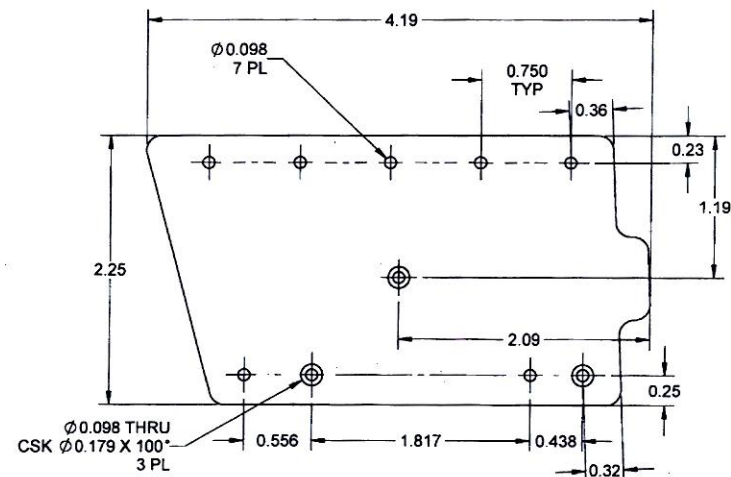
D4482-1 INTERCOSTAL 5 (LH)



SECTION A-A

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



D4482-3 HINGE PLATE (LH)

RELEASED
2012-11-29

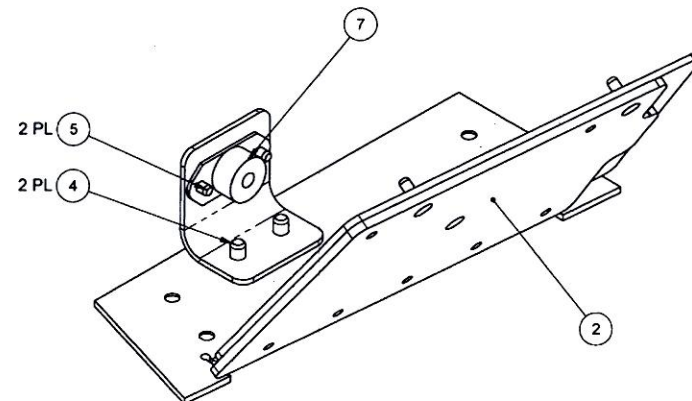
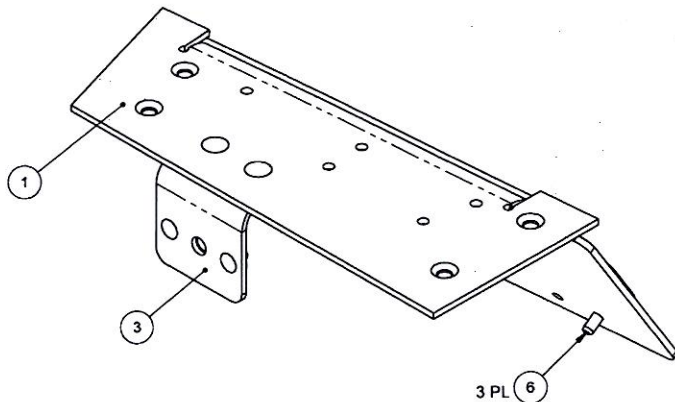
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REV.C.DXF"

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	
DATE	12.10.05	NTS	

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM	QTY -042	P/N	DESCRIPTION
	X	D4482-042	INTERCOSTAL 5 ASSY (RH)
1	1	D4482-2	INTERCOSTAL 5 ASSY (RH)
2	1	D4482-4	HINGE PLATE (RH)
3	/1	D4488-1	CLIP
4	2	MS20426AD4-4	RIVET, CSK
5	2	MS20426AD3-3	RIVET, CSK
6	3	MS20426AD3-5	RIVET, CSK
7	1	MS21059L08	NUTPLATE

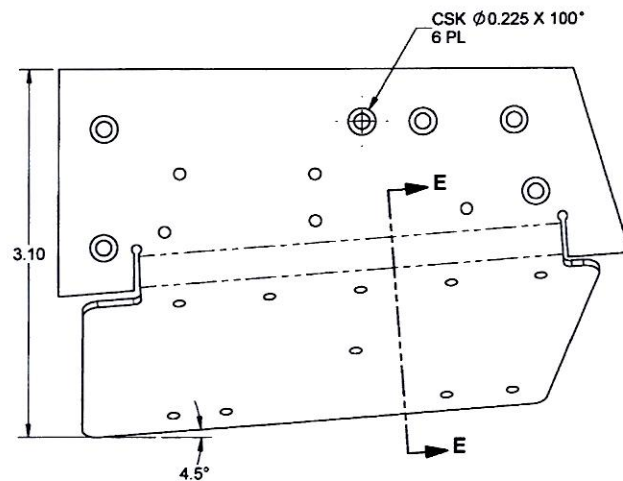


NOTES:

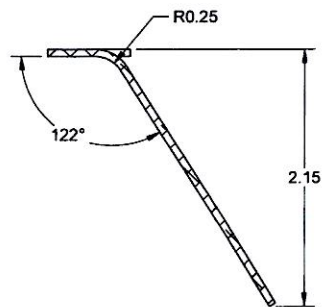
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE INTERCOSTAL 5 ASSY	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.10.05		

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2012-11-29
[Signature]



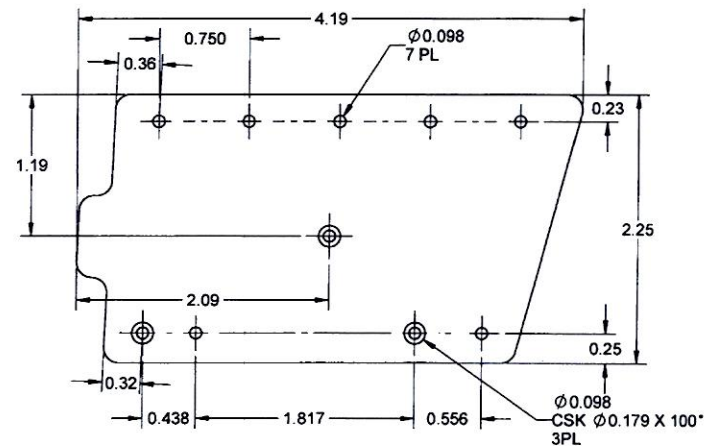
D4482-2 INTERCOSTAL 5 ASSY (RH)



SECTION E-E

NOTES:

- 1) MATERIAL: MAKE FROM D4482-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



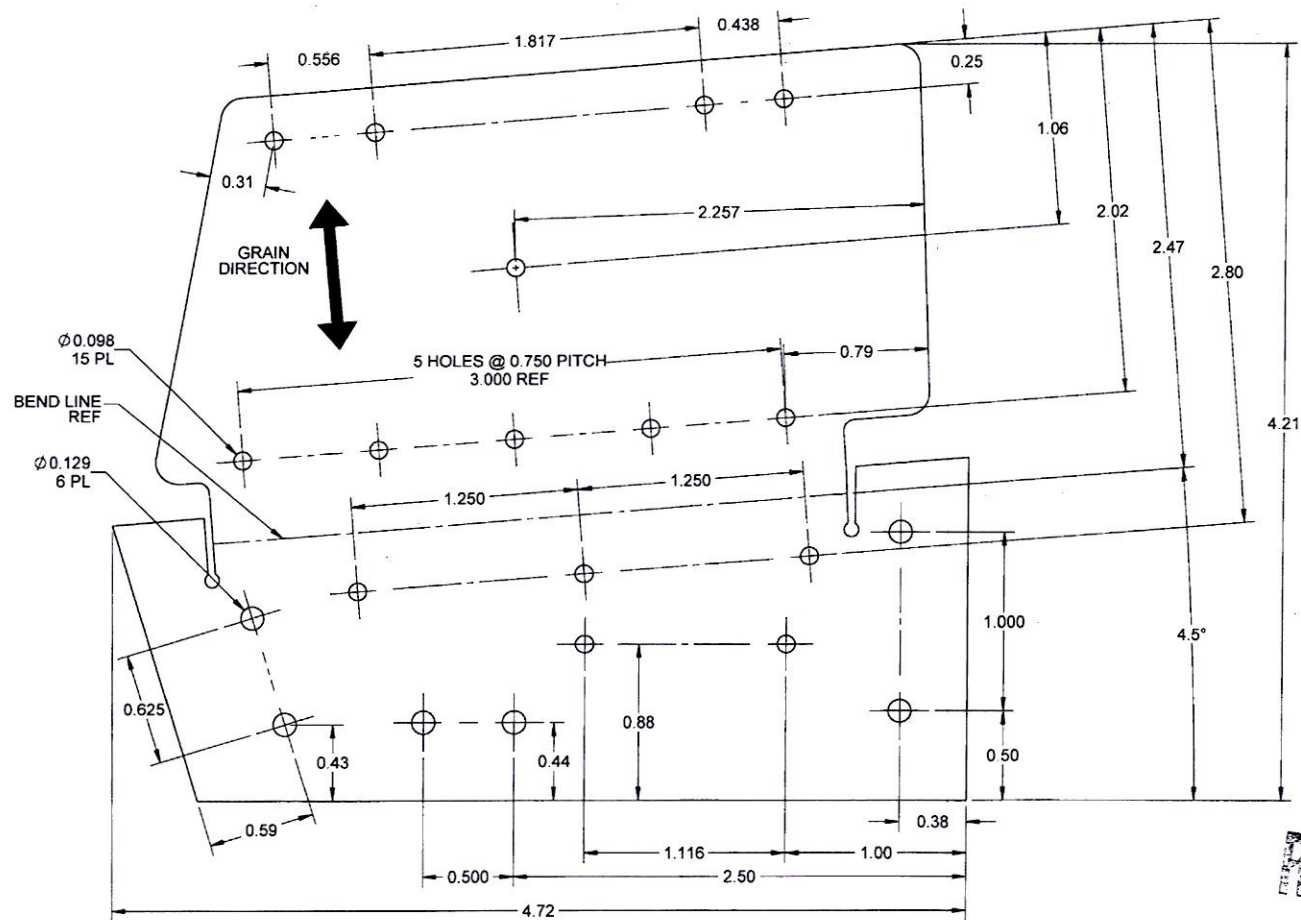
D4482-4 HINGE PLATE (RH)

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs
- 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-3-REVC.DXF"

RELEASED
2012-11-29
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4482	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INTERCOSTAL 5 ASSY	NTS
DATE	12.10.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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2012-11-29
MD

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER AMS 4025 OR AMS 4027 OR ASTM B209
REF M6061T6S.063
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs
 - 8) ALL NON DIMENSIONED FEATURES PER DRAWING FILES "D4482-1F-REV.C.DXF"

D4482-1F INTERCOASTAL 5
(FLAT PATTERN)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4482	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INTERCOSTAL 5 ASSY	
DATE	12.10.05	NTS	
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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>153573</u> Part No. <u>D448Z-04Z</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐																																																								
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																								
Large Fab ☐	Composite ☐	Supplier ☐																																																									
Date : <u>16/12/15</u>		Step #: <u>110</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval DAS 12 9-89 <u>16/12/15</u>																																																					
Description Work Order Deviation Qty(3) holes were countersunk on D448Z-2 that correspond to countersunk holes on D448Z-4.				Disposition Acceptable. Holes hold plate to intercastel and also they do not see high load. Countersunk is hidden & doesn't interfere with rivet installation				Completed By DAS 12 9-89 <u>16/12/15</u> Lead hand / Supervisor Approval Verification DAS 38 <u>DEC 06 2016</u> QC / QA Coordinator Approval DAS 38 <u>DEC 06 2016</u>																																																			
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ ☒ Countersink Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ ☒ Countersink Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Environment	☐	No Re-verification	☐																																																								
Design	☐	Operator	☐																																																								
Doc/Data	☐	Offset/Setup	☐																																																								
Equip/Tooling	☐	Supplier	☐																																																								
Handling/Pre	☐	Training	☐																																																								
Material	☐	Use for Testing	☐																																																								
Internal Transport	☐	Poor Information	☐																																																								
Tribal Knowledge	☐	Rushing	☐																																																								
LOA	☐	Product Improvement	☐																																																								
Substation	☐	Process Improvement	☐																																																								
Past Expiry Date	☐	Manufacturing Process	☐																																																								
Misidentified	☐	Past Due	☐																																																								
Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ ☒ Countersink Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																																																								
OTHER : _____																																																											